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JIS

**JAPANESE
INDUSTRIAL
STANDARD**

Translated and Published by
Japanese Standards Association

JIS B 0601 : 2001

(ISO 4287 : 1997)

(JSA)

**Geometrical Product
Specifications (GPS)—
Surface texture : Profile method—
Terms, definitions and surface
texture parameters**

ICS 01.040.17; 17.040.20

Descriptors : roughness (surface), smoothness (surface), surface treatment, vocabulary

Reference number : JIS B 0601 : 2001 (E)

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B 0601:2001 (ISO 4287:1997)

4 Surface profile parameter definitions

4.1 Amplitude parameters (peak and valley)

4.1.1 maximum profile peak height P_p , R_p , W_p

largest profile peak height Z_p within a sampling length (see Figure 6)

Informative reference: The parameter is defined that P_p is "maximum profile peak height of primary profile", R_p is "maximum profile peak height of roughness profile" and W_p is "maximum profile peak height of waviness profile" which result in the replacement with the names of profiles relating to "profile". Hereafter the same rule applies. However, for a part of parameter of roughness profile and waviness profile, the terms familiarized traditionally or easy to call are used.

4.1.2 maximum profile valley depth P_v , R_v , W_v

largest profile valley depth Z_v within a sampling length (see Figure 7)

4.1.3 maximum height of profile P_z , R_z , W_z

sum of height of the largest profile peak height Z_p and the largest profile valley depth Z_v within a sampling length (see Figure 8)

NOTE: In ISO 4287:1984, the R_z symbol was used to indicate the "ten point height of irregularities". In some countries there are surface roughness measuring instruments in use which measure the former R_z parameter. Therefore, care must be taken when using existing technical documents and drawings because differences between results obtained with different types of instruments are not always negligibly small.

Informative reference: If the profile is the roughness profile, R_z is "roughness of maximum height" and if the surface profile is the waviness profile, W_z is "waviness of maximum height".

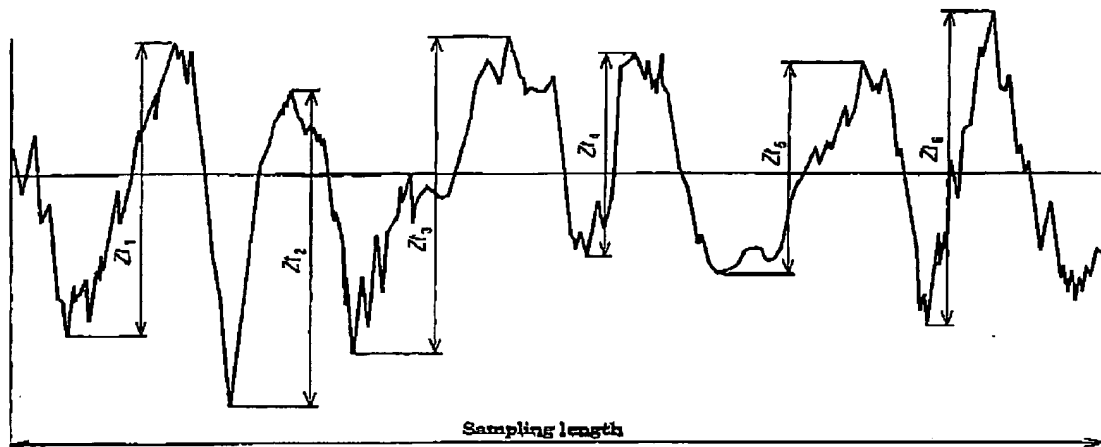


Figure 9 Height of profile elements
(example of a roughness profile)

4.2 Amplitude parameters (average of ordinates)

4.2.1 arithmetical mean deviation of the assessed profile P_a , R_a , W_a
arithmetical mean of the absolute ordinate values $Z(x)$ within a sampling length

$$P_a, R_a, W_a = \frac{1}{l} \int_0^l |Z(x)| dx$$

with $l = l_p, l_r$ or l_w according to the case.

Informative reference : If the profile is the roughness profile, R_a is called "arithmetical mean roughness" which is traditionally familiar term and if the profile is the waviness profile W_a is called "arithmetical mean waviness".

4.2.2 root mean square deviation of the assessed profile P_q , R_q , W_q
root mean square value of the ordinate values $Z(x)$ within a sampling length

$$P_q, R_q, W_q = \sqrt{\frac{1}{l} \int_0^l Z^2(x) dx}$$

with $l = l_p, l_r$ or l_w according to the case.

Informative reference : If the profile is the roughness profile, R_q is called "root mean square roughness" and if the profile is the waviness profile, W_q is called "root mean square waviness".

4.2.3 skewness of the assessed profile P_{sk} , R_{sk} , W_{sk}

quotient of the mean cube value of the ordinate values $Z(x)$ and the cube of P_q , R_q or W_q respectively, within a sampling length

Annex C Table 2 Parameters of surface texture

Clause in JIS B 0601 : 2001	Parameters, JIS B 0601 : 2001	JIS B 0601 : 1994 and JIS B 0830 : 1988	JIS B 0601 : 2001	Determined within evaluation length l_n	Sampling length ^(*)
4.1.1	Maximum profile peak height	R_p	$Pp^{(*)}$		○
4.1.2	Maximum profile valley depth	R_n	$Ro^{(*)}$		○
4.1.3	Maximum height of the profile	R_z	$Rz^{(*)}$		○
4.1.4	Mean height of profile elements	R_s	$Rc^{(*)}$		○
4.1.5	Total height of profile	—	$Rt^{(*)}$	○	
4.2.1	Arithmetical mean deviation of the assessed profile	R_a	$Ro^{(*)}$		○
4.2.2	Root mean square deviation of the assessed profile	R_q	$Rq^{(*)}$		○
4.2.3	Skewness of the assessed profile	S_k	$Rsk^{(*)}$		○
4.2.4	Kurtosis of the assessed profile	—	$Rku^{(*)}$		○
4.3.1	Mean width of the profile elements	S_m	$RSm^{(*)}$		○
4.4.1	Root mean square slope of the assessed profile	Δ_q	$Rdq^{(*)}$		○
4.5.1	Material ratio of the profile	t_p	$Rmr^{(*)}$	○	
4.5.3	Profile section height difference	—	$Rdc^{(*)}$	○	
4.5.4	Relative material ratio	—	$Rmr^{(*)}$	○	
—	Ten point height (deleted as an ISO parameter)	R_z	$Rz^{(*)}$		○

Notes (*) This sampling length is l_r , l_w and l_p for R , W and P -parameters respectively; l_p is equal to l_n .

(*) Parameters which are defined for three profiles: primary profiles, waviness profiles and roughness profiles. Only the roughness profile parameter is indicated in the table. As an example, the three parameters are written Pz (primary profile), Wz (waviness profile) and Rz (roughness profile).

(*) Ten-point height of roughness profile is the symbol for parameter used only in JIS, and does not apply to the primary profile and waviness profile. Informative references 1 If the profile is the roughness profile, R_z is called "roughness of maximum height", R_z is "arithmetical mean roughness" and Ry is "root mean square roughness". In addition, if the profile is the waviness profile, W_z is called "waviness of maximum height", W_o is "arithmetical mean waviness" and Wq is "root mean square waviness".

2 In the original International Standard, t_p is defined as relative material ratio in the 1984 edition, but it was material ratio. The error is corrected in this Standard.

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B 0601 : 2001 (ISO 4287 : 1997)

Annex 1 (informative)
Ten-point mean roughness

Ten-point mean roughness is the roughness parameter which is not included in the original International Standard (ISO 4287 : 1997) but is left in this Annex for information because it is widely popularized in Japan.

1 Ten-point height of roughness profile R_{zms} In the roughness curve of the reference length obtained by applying a phase compensation zone passing filter of the cut-off values λ_c and λ_s , the sum of the mean of profile peaks from the highest to fifth height and the mean of profile depths from the deepest valley to fifth deepest valley.

Remarks : If the maximum height roughness R_z based on this Standard is confused with R_z used for ten-point mean roughness which has been used in the past technical documents, the difference should be shown in note or the like.

2 Definitions of ten-point height of roughness profile given in the former standard The ten-point mean roughness specified in the obsolete standards JIS B 0601 : 1982, JIS B 0601 : 1994 and JIS B 0660 : 1998 is widely used in Japan and accumulated in the technical documents in the past.

Remarks : The ten-point mean roughness is the same in JIS B 0601 : 1994 and in JIS B 0660 : 1998.

- a) **Definition of ten-point mean roughness in the former standard JIS B 0601 : 1994** In the roughness curve of the reference length (roughness curve in the former JIS B 0601 : 1994) obtained by applying a phase compensation high-pass filter of the cut-off value λ_c (phase compensation low-pass filter of the cut-off value λ_s is not applied), the sum of the mean of five profile peaks from the highest to fifth height and the mean of five profile depths from the deepest valley to fifth deepest valley.

If the difference between the ten-point mean roughness based on the former standard JIS B 0601 : 1994 and the above-mentioned R_{zms} is anxious, the parameter symbol of R_{zms} is used for the ten-point mean roughness based on the former standard JIS B 0601 : 1994. When describing the contents of the symbol, the description in Annex 1 Table 1 is recommended to be seen.

Remarks : The roughness curve defined in the former standards JIS B 0601 : 1994 and JIS B 0660 : 1998 does not exist at present.

- b) **Definition of ten-point mean roughness in the former standard JIS B 0601 : 1982** The definition is given as the sum of the mean of five profile peaks from the highest to fifth height and the mean of five profile depths from the deepest valley to fifth depth in the primary profile of the reference length (the data measured as they are without any treatment such as filtering). The ten-point mean roughness based on this Standard is that which has been obtained using an analog type surface roughness tester. There may be a difference from R_{zms} defined above as the ten-point mean roughness based on the former standard JIS B 0601 : 1982, so that, if it is necessary to distinguish these two symbols,

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